

Work Order ID 96094

96094

Page 1

Sunday, January 20, 2013 7:38:38 AM

Item ID: D4567-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Knob

Start Date: 1/21/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/1/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

MK

Date: 13-1-21

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4567

PAZ

REC. A

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 18881

knob

Possible Supplier: McMaster-Carr

P/N: 6077K11

Material release note required

CL 13/01/21 (4)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material release note is attached

10/3/23 (4)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

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Reference:

Approvals: Process Plan:

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 5114

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

*1/23/13 5 (4)**1/31/28**1/13/28*

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
---	---	---

<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Sunday, January 20, 2013 7:38:38 AM

Page 1

Work Order ID: 96094

Parent Item: D4567-1

Parent Item Name: Knob

Start Date: 1/21/2013

Required Date: 2/1/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP revA 12.01.10 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6077K11 Knob		Purchased	No			110	Each	0.0000	1	4			

P43/01/13 302

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

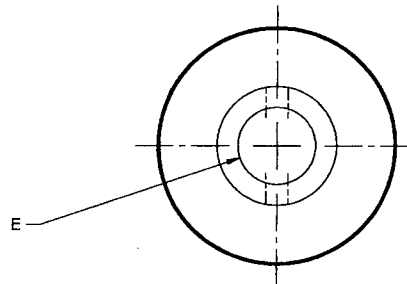
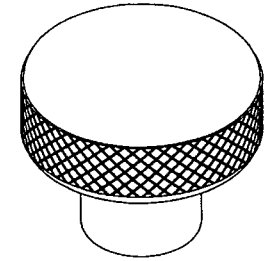
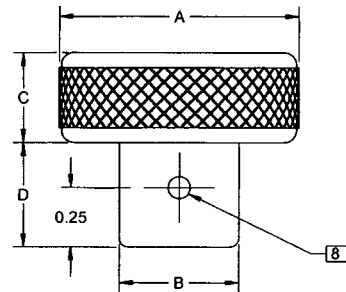
DQA: _____ Date: _____

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Unapproved											

FAULT CATEGORY				
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SPECIFICATION CONTROL DRAWING



D4567-X KNOB

DART PART NUMBER	SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	A (IN)	B (IN)	C (IN)	D (IN)	E (IN)	WEIGHT
D4567-1	MCMaster-CARR	6077K11	ALUMINUM	1.000	0.500	0.375	0.438	0.250 X 0.063 DP	0.04 lb

RELEASED
2012-03-08
MP

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE TABLE
- 8) DRILL $\varnothing 0.046$ THRU HOLE ON D4567-1 ONLY, PERFORMED AT DART

A	NEW ISSUE	AP	12.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP	DRAWING NO.	REV. A
CHECKED	AP	D4567	SHEET 1 OF 1
MFG. APPR.	MP	TITLE	SCALE
APPROVED	MP	KNOB	NTS
DE APPR.	MP	DATE 12.02.27	
<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

NCR: Yes / No

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FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO18881**

Purchase Order Date 1/21/13

PO Print Date 1/21/13

Page Number 2 of 4

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

330 995 5500

330 995 9600

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

USD

Destination-Collect

5	5616A61 SQUARE NOSE PLIERS	1/23/13	✓ 1.00	FedEx PI collect	\$34.7100	\$34.71
		Yes	Each			

Deliver To: FINISHING

6	4597T3 LOCKER DARK GREY	1/23/13	✓ 2.00	FedEx PI collect	\$152.8200	\$305.64
		Yes	Each			

Deliver To: STORES

7	4597T4 LOCKER DARK GREY	1/23/13	✓ 1.00	FedEx PI collect	\$135.2700	\$135.27
		Yes	Each			

Deliver To: STORES

8	MSIL60S.125	high temp. silicone sheet .125	1/23/13	✓ 6.00	FedEx PI collect	\$20.2433	\$121.46
			Yes	sf			

Special Inst: MCMaster P/N: 8612K63

9	97395A461	Dowel Pin	1/23/13	✓ 30.00	FedEx PI collect	\$0.8410	\$25.23
			Yes	Each			

10	6077K11	Knob	1/23/13	✓ 4.00	FedEx PI collect	\$5.2600	\$21.04
			Yes	Each			

Change Nbr:

Change Date: 1/21/13

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required - YES NO



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

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Purchase Order Date 1/21/13

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Page Number 3 of 4

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VU-MCM001

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

330 995 5500

330 995 9600

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 10

Currency

USD

FOB

Destination-Collect

Special Inst: AS PER DWG D4567 REV. A
B96094

11	D3373-1P	Cam Lock	1/23/13 Yes	6.00 Each	FedEx PI collect	\$6.0800	\$36.48
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Special Inst: AS PER DWG D3373 REV. A
B95705
MCMaster P/N: 1770A525 KEYED
ALIKE

12	3573A15	Washer	1/23/13 Yes	100.00 Each	FedEx PI collect	\$0.0748	\$7.48
----	---------	--------	----------------	----------------	------------------	----------	--------

Special Inst: AS PER DWG D4602 REV. A
B96092

13	D3373-5P	Cam Lock	1/23/13 Yes	30.00 Each	FedEx PI collect	\$6.0800	\$182.40
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Special Inst: AS PER DWG D3373 REV. A
B96256
MCMaster P/N: 1770A424 KEYED
ALIKE

14	4690A172 80 GRIT SANDING ROLL	1/23/13 Yes	3.00 Each	FedEx PI collect	\$6.2000	\$18.60
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Deliver To: DAN.P

Special Inst: 3 PK OF 25

Change Nbr: 4

Change Date: 1/21/13

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required - YES NO

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.comDart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
CanadaOrder Placed By
Chantal Lavoie

01/21/2013

McMaster-Carr Number
6267235-02

Line	Description	Ordered	Shipped	TAG
7	4597T4 Contemporary-Style Unassembled Steel Locker, Add-on, 2-Tier, 12" W X 36" H X 18" D Openings, Dark Gray Your Part Number: STORES	1 Each	1 ✓	7 - 110
	Unit Price: \$135.27 Extended Price: \$135.27			
8	8612K63 Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/8" Thick, 24" X 36" Your Part Number: MSIL60S.125	1 Each	1 ✓	8 - 75
	Unit Price: \$121.46 Extended Price: \$121.46			
9	97395A461 Corrosion Resistant Dowel Pin, Type 316 Stainless Steel, 3/16" Diameter, 1/2" Length, Packs of 10	3 Packs	3 ✓	2 - 692
	Unit Price: \$8.41 Extended Price: \$25.23			
10	6077K11 Aluminum Knurled-Rim Knob, without Handle, 1/4" Unthreaded Hole, 1" Diameter	4 Each	4 ✓	3 - 471
	Unit Price: \$5.26 Extended Price: \$21.04			
11	1770A525 Cam Lock with Polished Nickel Finish, Keyed to C420A, 3/4" Diameter Hole, 7/64" Material Thickness Your Part Number: D3373-1P	6 Each	6 ✓	1 - 698
	Unit Price: \$6.08 Extended Price: \$36.48			
12	3573A15 Corrosion-Resistant Acetal Spring Washer, 1/4"/M6 Screw Size, .26" ID, .56" OD, Packs of 100	1 Pack	1	2 - 699
	Unit Price: \$7.48 Extended Price: \$7.48			
13	1770A424 Cam Lock with Polished Nickel Finish, Keyed to C420A, 3/4" Diameter Hole, 1-1/8" Material Thickness Your Part Number: D3373-5P	30 Each	30 ✓ <i>Robert</i>	1 - 696
	Unit Price: \$6.08 Extended Price: \$182.40			